

152385

Monday, October 24, 2016 11:19:37 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

3

3

Customer:

Run Start *NR1*

DAS
21
9-89

Date OCT 24 2016**Tooling:**

Date:

Stop *NR2*

QC:

Date:**SPC (Y/N):**

Date:

[illegible]

DEC 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER :			
Misidentified ☐		Past Due ☐					

Work Order ID 152385***152385***

Page 2

Monday, October 24, 2016 11:19:37 AM

Item ID: D407-559-115

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

DAS
27
9-89

DEC 08 2016

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

DAS
21
9-89

DEC 08 2016

DAS
21
9-89

DEC 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
		OTHER : _____									

Picklist Print

Monday, October 24, 2016 11:19:40 AM

Page 1

Work Order ID: 152385

152385

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2274		Manufactured	No				Each	201.0000		36			
-------	--	--------------	----	--	--	--	------	----------	--	----	--	--	--

D2274

Radius Block

Location	Loc Qty	Loc Code
----------	---------	----------

FG	12	
----	----	--

86855	12	
-------	----	--

ST006	189	
-------	-----	--

150353	34	
--------	----	--

150676	155	
--------	-----	--

D2529		Manufactured	No				Each	603.0000		36			
-------	--	--------------	----	--	--	--	------	----------	--	----	--	--	--

D2529

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST008	603	
-------	-----	--

150080	500	
--------	-----	--

150996	103	
--------	-----	--

D2432-3		Manufactured	No				Each	1.0000		6			
---------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D2432-3

206 (24") Bearpaw

Location	Loc Qty	Loc Code
----------	---------	----------

ST454a	1	
--------	---	--

139891	1	
--------	---	--

D4011-1		Manufactured	No				Each	75.0000		18			
---------	--	--------------	----	--	--	--	------	---------	--	----	--	--	--

D4011-1

Clamp, Short

Location	Loc Qty	Loc Code
----------	---------	----------

ST544	75	
-------	----	--

151217	75	
--------	----	--

20x-B/51763

DAS 28 26 9-89
NOV 16 2016

DAS 27 9-89

DAS 27 9-89

DAS 6 9-89

DAS 27 9-89

DAS 27 9-89

DAS 28 26 9-89
NOV 16 2016

DAS 28 26 9-89

DAS 28 26 9-89
NOV 16 2016

36x
NOV 14 2016
15x29

6

18x

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Monday, October 24, 2016 11:19:40 AM

Page 2

Work Order ID: 152385

152385

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

D4012-1

Manufactured No

Each

93.0000

18

D4012-1

Cushion

**

6

DAS
26
9-89
DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

88

151095

46

151752

42

Each

69.0000

**

12

36

LEX
M135966

DAS
26
9-89
DAS
28
9-89

NOV 15 2016

AN4-20A

Purchased

No

AN4-20A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

6

m116419

6

ST343

63

m135056

13

m135600

50

Each

2,230.000

**

12

36

NOV 15 2016

NAS1149D0463J

Purchased

No

NAS1149D0463J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

cnc

200

M135671

200

GA

135

M134508

32

M135056

103

ST260a

1000

M135767

1000

ST263

895

M135530

95

M135671

800

3lex

NOV 15 2016

Monday, October 24, 2016 11:19:40 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Page 3

Work Order ID: 152385

152385

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

Each

2,214.000

36

MS21042L4

Nut

DAS
26
9-89

NOV 15 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

260

m135058

260

OVER007

1500

m135774

500

m135864

1000

ST303

420

m135704

420

36x

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 Rev. L AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 3

REF CANADIAN STC: SH92-17
REF FAA STC: SH1031NE
REF LBA STC: 0796/3034
REF JCAB STC: STC-90-TYO
REF BRAZIL STC: 2010S10-08

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152385 MJS
16-10-24

1.0 PURPOSE

The purpose of this Dart Service Instruction is to add the D407-559-115 Bearpaw Kit to this approval. The D407-559-115 Bearpaw Kit is designed to be compatible with D206-642-311/-312/-313/-314/-411/-412/-413/-414 Skidtubes equipped with D206-642-XXX Run-On Landing Wearplates. The D407-559-115 Bearpaw Kit is also compatible with the D206-642-XXX Skidtubes equipped with standard wearplates/wearshoes.

2.0 INSTALLATION

To install D407-559-115 Bearpaw Kit on Dart D206-642-XXX Skidtubes equipped with D206-642-XXX Run-On Landing Wearplates refer to Figures 1 & 2 of this Service Instruction as well as the following:

- 2.1 Jack up the aircraft and ensure the skidtubes are serviceable in accordance with ICA-D206-642.
- 2.2 Position D2432-3 Bearpaw on the aft end of each skidtube so that the bearpaw clamps are located on either side of the aft saddle as shown in Figure 1a - 1c of this Service Instruction. The bearpaws should be installed over the run-on landing wearplates.
- 2.3 Attach the D4011-1 Clamps with D4012-1 Cushions using hardware shown in Figure 2 of this Service Instruction. Additional AN960JD416 (or NAS1149D0463J) washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-20A bolts with longer or shorter AN4 bolts, if required.

CAUTION: The torque on the nuts should be limited to 20 in-lb (2.3 Nm)

- 2.4 Lower the aircraft.
- 2.5 Update the aircraft log book to indicate installation of the D407-559-115 Bearpaw Kit and adjust the empty weight and balance record for the rotorcraft with the information given in section 5.0 of this service instruction.

3.0 MAINTENANCE

The D407-559-115 Bearpaw Kit should be maintained in accordance with ICA-D206-559.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	12.07.05
CERT. NO.:	SH92-17
ISSUE NO.:	7

A	NEW ISSUE	AP	12.07.05
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	qp	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9624	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BEARPAW INSTALLATION	NTS
DATE	12.07.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

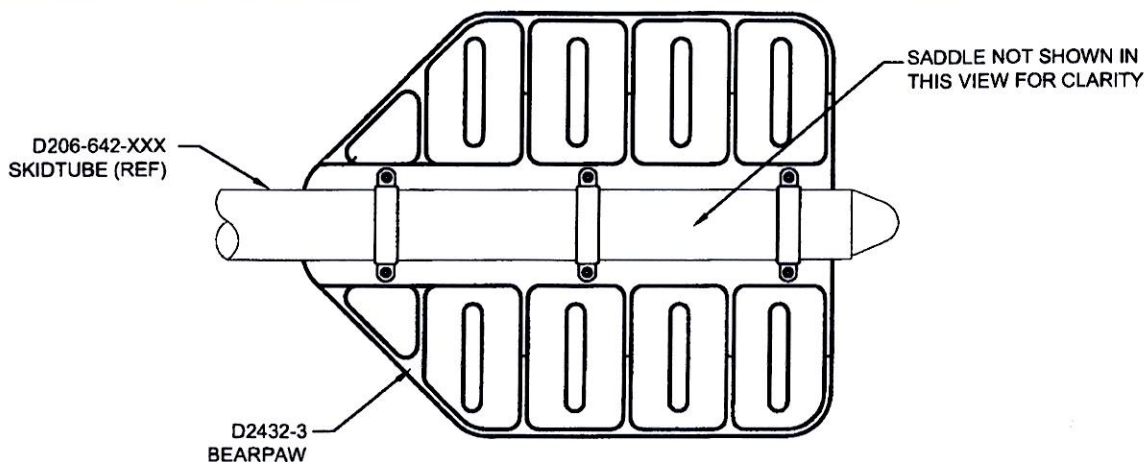
WORK ORDER NON-CONFORMANCE / UPDATE



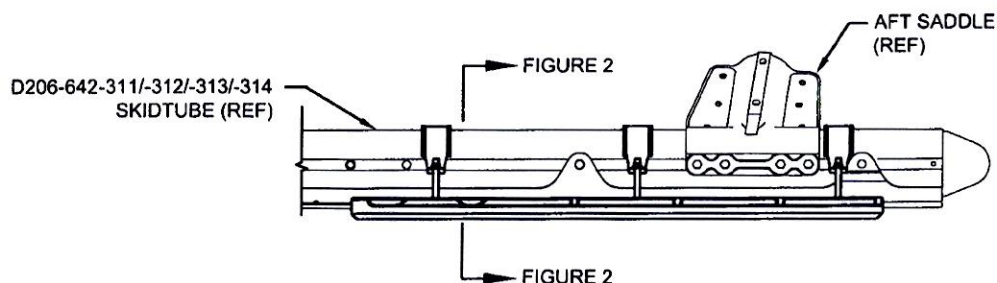
QA Closed: _____ Date: _____

Work Order update only ☐

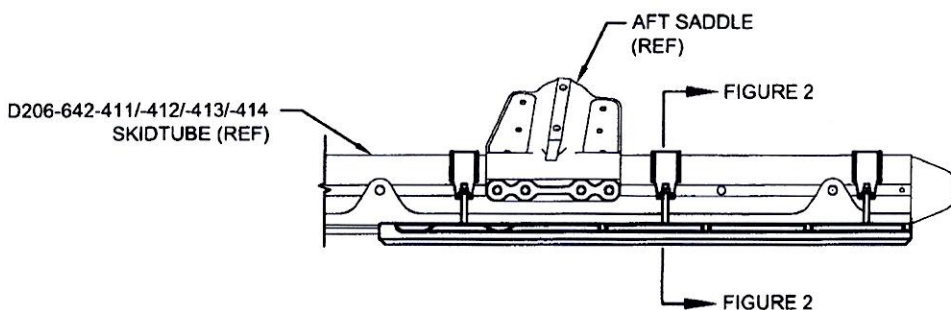
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		OTHER :							



**Figure 1a - Bearpaw Location
(Top View)**



**Figure 1b - Bearpaw Installation (Side View)
(Installed on D206-642-311/-312/-313/-314 Skid tubes)**



**Figure 1c - Bearpaw Installation (Side View)
(Installed on D206-642-411/-412/-413/-414 Skid tubes)**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9624	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BEARPAW INSTALLATION	NTS
DATE	12.07.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

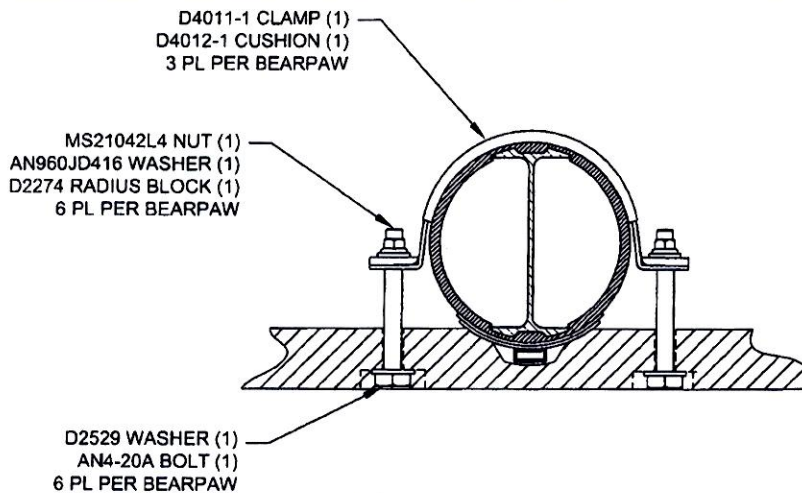


Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
X	D407-559-115	BEARPAW INSTALLATION
12	D2274	RADIUS BLOCK
12	D2529	WASHER
2	D2432-3	BEARPAW
6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AP	
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9624 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		BEARPAW INSTALLATION NTS
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

5.0 WEIGHT AND BALANCE

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D407-559-115 Bearpaw installation (Bell 407 High Gear)	13.9 lb 6.30 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	148 in 3.76 m	2057 in-lb 23.69 m-kg
D407-559-115 Bearpaw installation (Bell 206L/407 Low Gear)	13.9 lb 6.30 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	149 in 3.78 m	2071 in-lb 23.81 m-kg
D407-559-115 Bearpaw installation (Bell 206 L High Gear)	13.9 lb 6.30 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157 in 3.99 m	2182 in-lb 25.14 m-kg

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: 
D. SHEPHERD (DE # 02)

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CERT. NO.: SH92-17

ISSUE NO.: 7

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9624	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BEARPAW INSTALLATION	NTS
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 152385

Monday, November 14, 2016 9:11:17 AM

152385

Page 1

Item ID: D407-559-115 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible
Start Date: 10/24/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 11/4/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9624	REV A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D407-559-115 CHC001								
151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

NOV 14 2016

3

DAS
21
9-89

see attachment

Change Record

PAGE 1 OF 1

Part Number: D407-559-115

Description: BEARPAW INSTALLATION

[illegible]

REFERENCE ONLY

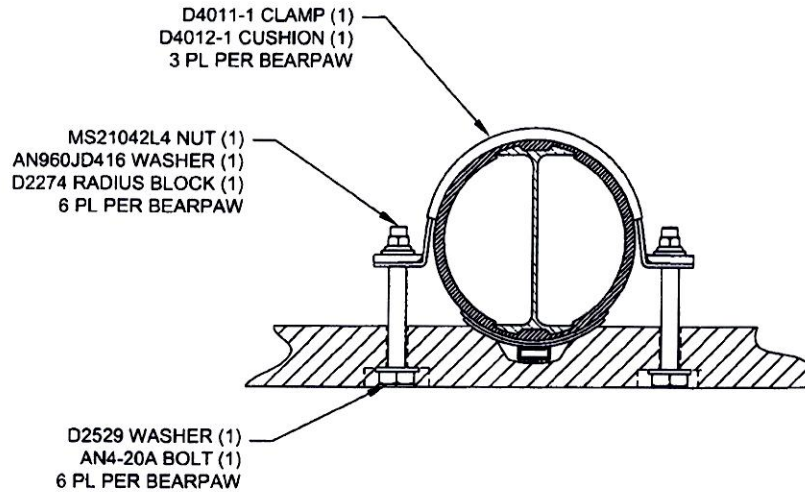


Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
12	D407-559-115	BEARPAW INSTALLATION
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6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH92-17
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